

Work Order ID 137539***137539***

Page 1

October 05, 2015 11:45:32 AM

Item ID: D3186-2M Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacepod Door RH
Start Date: 10/5/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/19/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: SLA Date: 120151005 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3186	Rev E								

100 PURCHASING 0.00

100

Purchasing

Purchasing

Memo

Issue P/O:

Description: D3186-2P Door

Supplier: Delastek

Conformity Certificate and Process sheet required

FEB 17 2016

OCT 06 2015

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Packaging

Memo

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

120 QC6- Inspect dimensions to drawing 0.00

120

QC

Quality Control

Memo

Check for void spot and pins.

DAS
16
9-8910/12/02
P.T.O.

DQA:

Date:

2017-07-21



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

JUL 20 2017

Work Order update only ☐

Work Order: <u>137539</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. <u>D3186-2/M</u>		Rework ☒		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. <u>16-5733</u>		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☒			
Date: <u>16-04-20</u>		Step #: <u>100</u>		QTY Effective: <u>1</u>			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Holes for hinge bracket are not to drawing. see NCR16-5733 R.C. supplier								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☒ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☒ Misaligned/off center ☐ Turning Sequence ☐					
OTHER: ☐									



Supplier Non-Conformance Report

Reviewed
DQA:
Date:

Printed on: Tuesday, October 18, 2016

Details

Raised Date 4/20/2016	Status Closed	Owner Downing, Eric M	Number NCR16-5733
Target Date 8/5/2016	Standard	Severity MINOR	
Process Inspection		Audit	
Raised By Person Duval, Patrick	Raised Against (Department or Supplier) FDC Composites Inc.		Fault Category General\Drill Holes
Details holes for hinge bracket on not to drawing (dimension 1.320" varies from 1.295"-1.370") see attach picture D3186-2M B135276/B135276 PO31394			
Keywords		Product D3186-2	
Document		Root Cause	
Closed By Downing, Eric M	Closed Date 7/19/2016	Resolution	

Corrective Action

Target Date 7/22/2016	Owner Downing, Eric M	Closed Date 7/19/2016	Closed By Downing, Eric M
Details supplier has been notified and has submitted there CA. awaiting for the return of 3 reworked doors to ensure NCR can be closed. was a PO issue not the correct information recorded on it. PO's have been adjusted			

Actions

Number	Owner	Target Date	Completed Date
Details			
1	Downing, Eric M	4/27/2016	4/21/2016
Contact Supplier and obtain corrective action		see attached email	
2	Downing, Eric M	4/29/2016	4/26/2016
perform a root cause investigation		see attached root cause investigation	
3	Duval, David	5/6/2016	5/3/2016
update BOM & ROUTE		done made the changes (-1mp/-2mp)	

4	Downing, Eric M	7/22/2016	7/15/2016
return door to FDC to have all holes & slots filled per QSI005 due to door must be a fwd. opening not vertical		doors were returned to FDC and will not be repairable and to be scraped. See attached Dart Audit report FDC	

Verification & Review

Target Date 7/22/2016	Owner Downing, Eric M	Closed Date 7/19/2016	Closed By Downing, Eric M
---------------------------------	---------------------------------	---------------------------------	-------------------------------------

Details

all actions have been completed

Actions

Number	Owner	Target Date	Completed Date
Details		Response	

Work Order ID 137539***137539***

Page 2

October 05, 2015 11:45:32 AM

Item ID: D3186-2M Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacepod Door RH
Start Date: 10/5/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/19/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							5 16/10/13
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							OCT 13 2016
Quality Control									

DAS
21
9-89

OCT 13 2016

DAS
21
9-89

OCT 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

October 05, 2015 11:45:38 AM

Page 1

Work Order ID: 137539

137539

Parent Item: D3186-2M

D3186-2M

Parent Item Name: Spacepod Door RH

Start Date: 10/5/2015

Required Date: 10/19/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-12-04 ec
IPP rev D rv D dwg 07.03.07 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3186-2P		Purchased	No			110	Each	0.0000	1	1			

D3186-2P

Spacepod Door

~~1X SP/6-04-18~~

1X SP/6-10-12

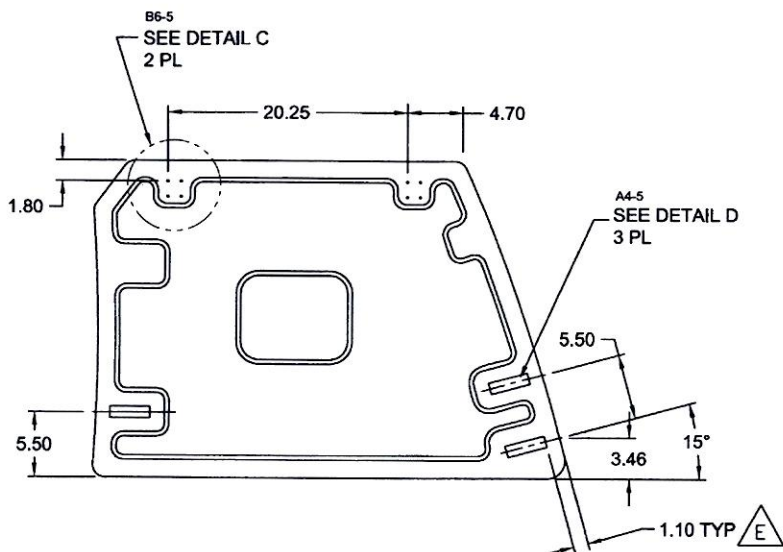
8 7 6 5 4 3 2 1

D

C

B

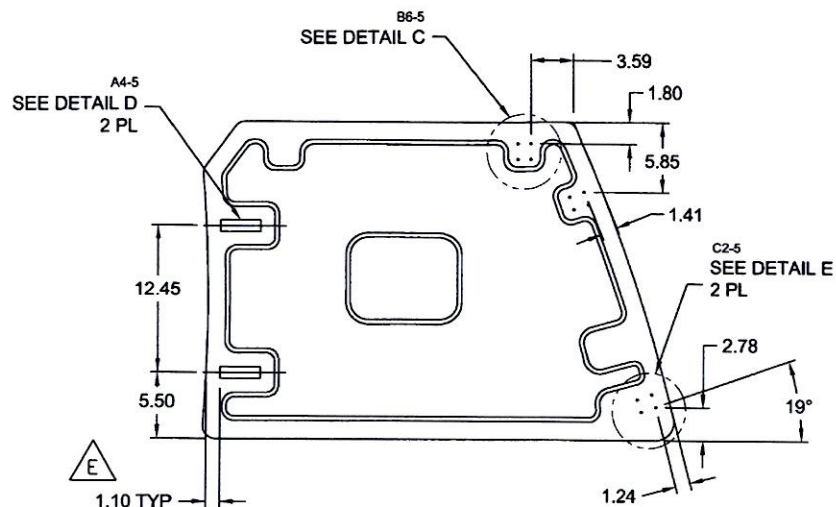
A



D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

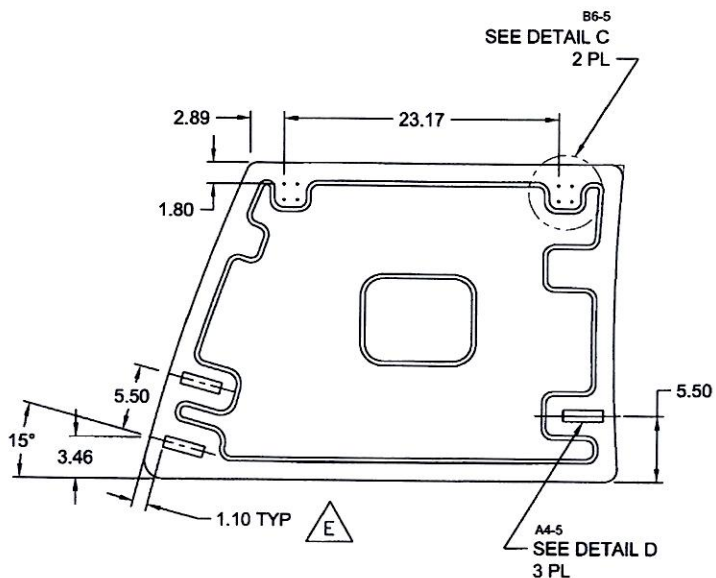
RELEASED
2009-09-09

20151005

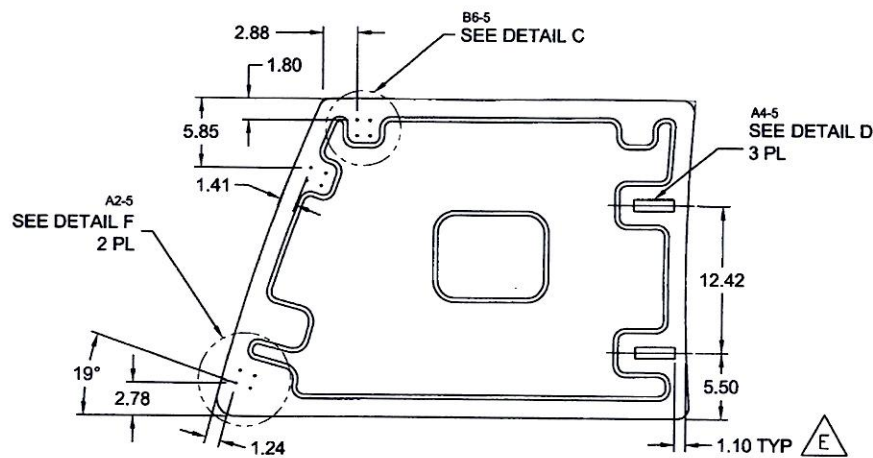
SH 137539

E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/2M/3/4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	JP	DRAWING NO.	REV. E
MFG. APPR.	JP	D3186	SHEET 1 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



D3186-2 SPACEPOD DOOR, RH
MAKE FROM D3186-2M



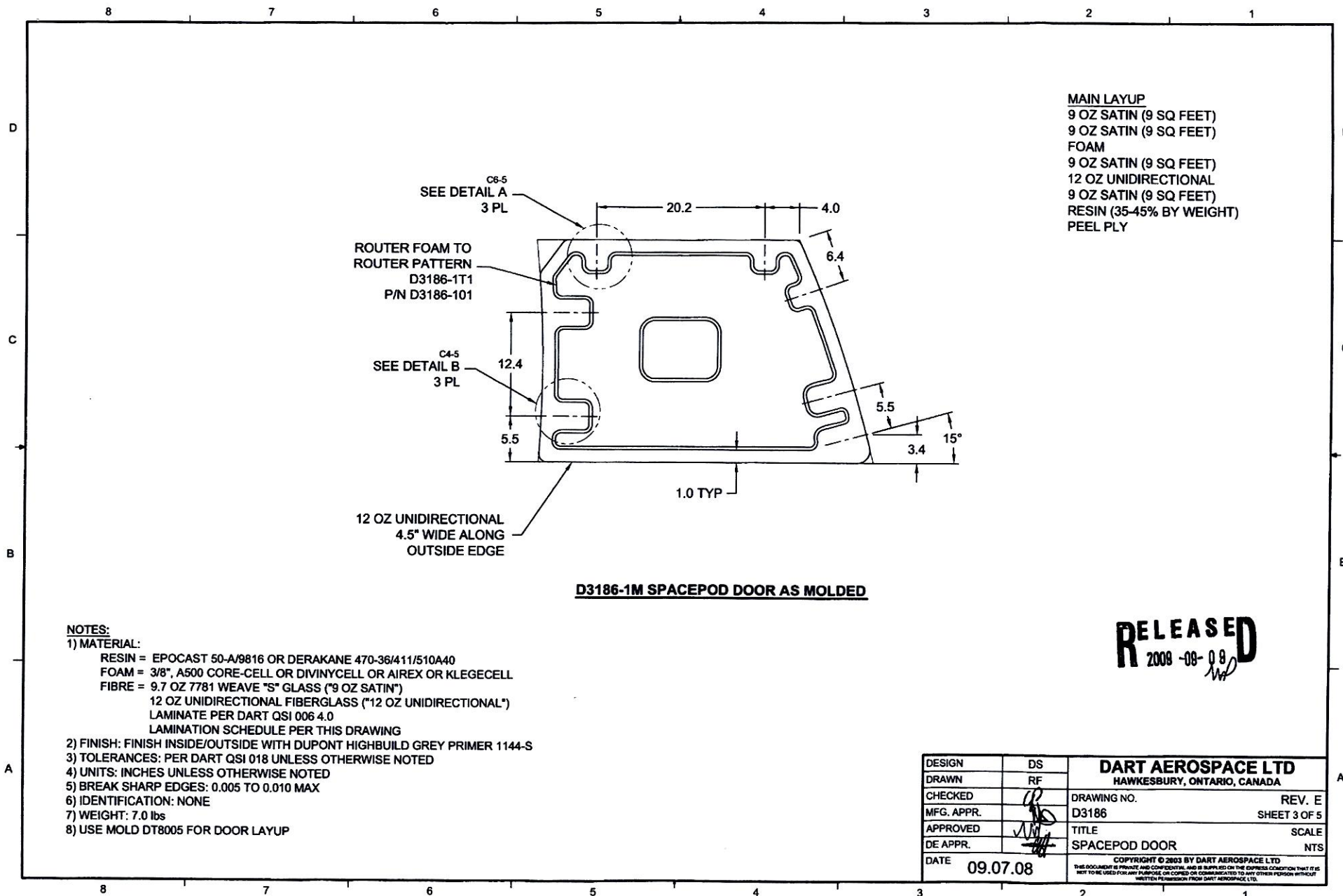
D3186-4 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

RELEASED
2008-09-09

NOTES:

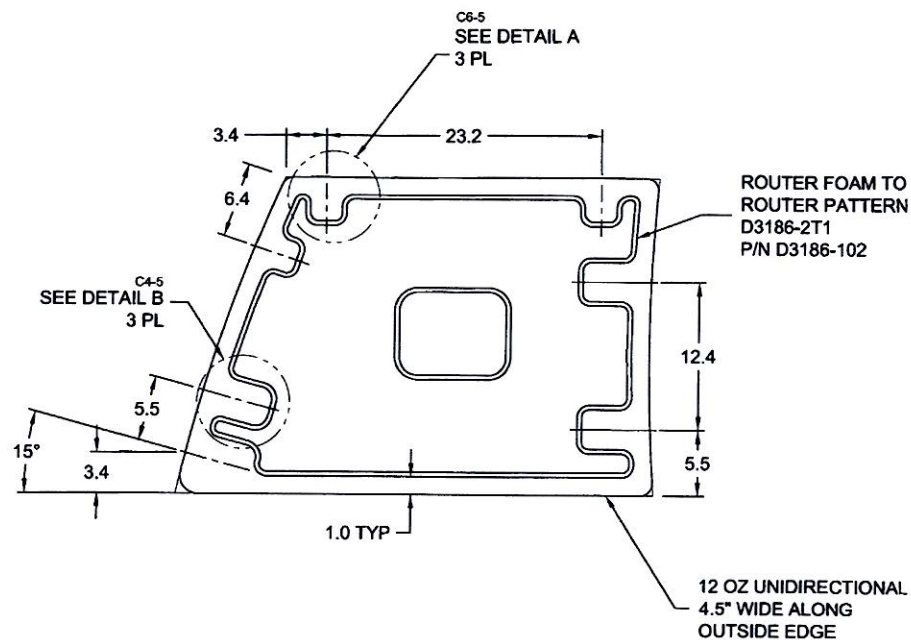
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
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MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY



D3186-2M SPACEPOD DOOR AS MOLDED

NOTES:

1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
 FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
 FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
 LAMINATE PER DART QSI 006 4.0
 LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

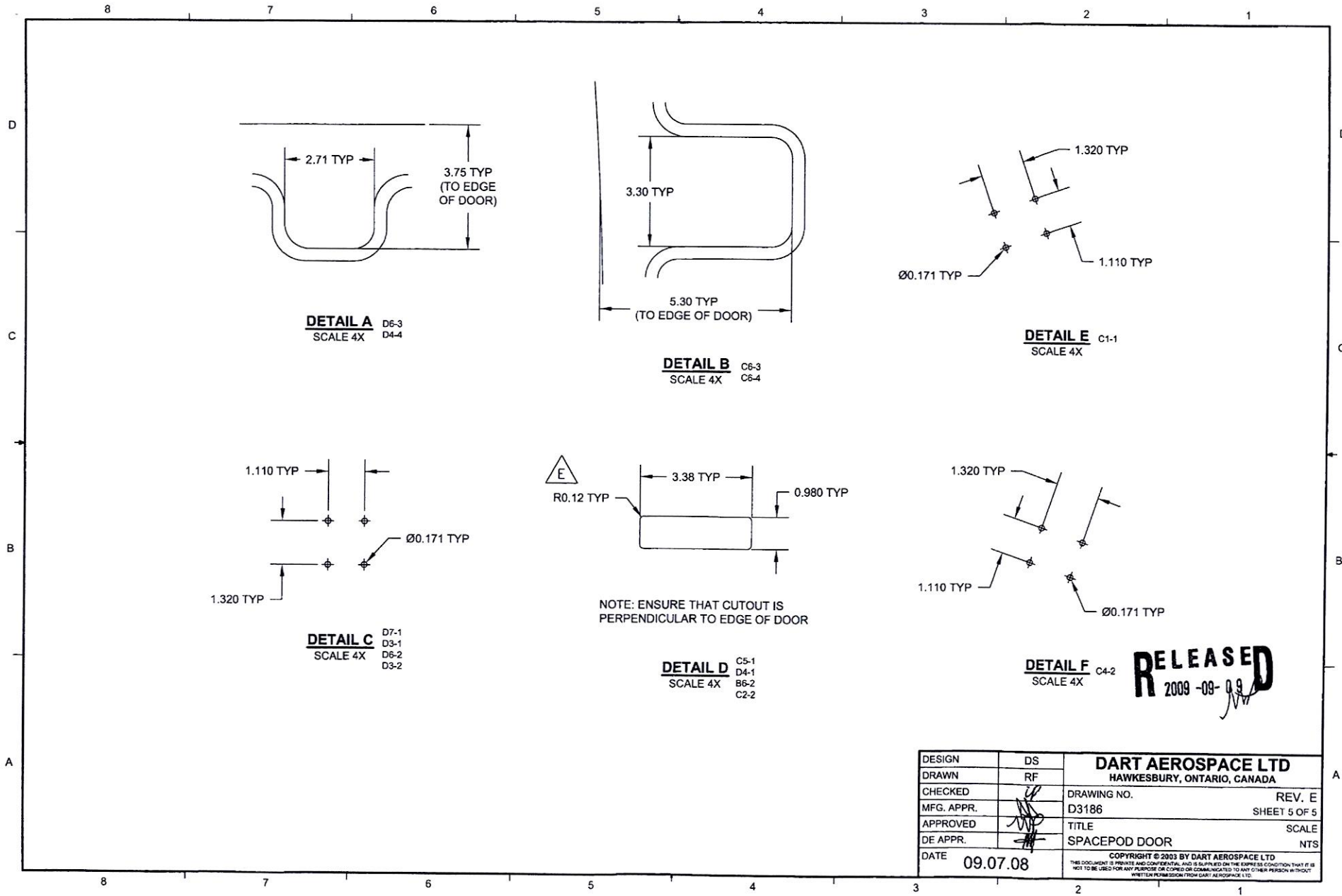
6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

8) USE MOLD DT8006 FOR DOOR LAYUP

RELEASED
 2009-09-09

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
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RELEASED
2009-09-09

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO31394**

Purchase Order Date 2/17/2016

PO Print Date 2/17/2016

Page Number 2 of 3

Order From :

VC-FDC01

FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

450-357-1344 ext303

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

Line Total:

\$2,460.00

4

D3186-2P

Spacepod Door

7/27/2016

Yes

7/27/2016

1.00

Each

\$810.00

\$810.00

AS PER DWG D3186 REV.E
B137539

Line Total:

\$810.00

5

D3188-2P

Spacepod Body

9/28/2016

Yes

9/28/2016

1.00

Each

\$2,460.00

\$2,460.00

AS PER DWG D3188 REV.G
B141768

Line Total:

\$2,460.00

6

D3186-2P

Spacepod Door

9/28/2016

Yes

9/28/2016

1.00

Each

\$810.00

\$810.00

AS PER DWG D3186 REV.E
B141767

Note:

2/17/2016

FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5 **Tél. : 450 357-1344**

Bon de livraison

31/03/2016

Commande : 2407
Référence : PO #31394/2/4

Client : Dart

Expédier à

DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Même

Tél. : 1 613 632-9577

No item	Description	Qté	Qté livrée	Qté B/O
D3186-2P	Spacepod Door PO item: 31394/2 Lot: 2016-03-14-1 B135276 FAI article	1	_____	_____
D3186-2P	Spacepod Door PO item: 31394/4 Lot: 2016-03-14-2 B137539	1 ✓	_____	_____

CANADIAN CURRENCY

Sp/6-04-18

Transport : _____

Réf. : _____

Nb colis : _____

Marchandise reçue : _____

CERTIFICATE of CONFORMITY

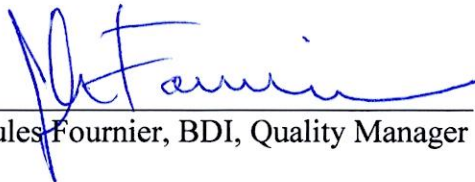
Customer Name: Dart Aerospace.

Customer P/O Number: 31394

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Dwg number Part</u>	<u>Dart ID</u>	<u>FDC ID</u>	<u>Lot</u>
2	1	D3186-2P Spacepod Doors	D3186 Rev.E	B135276	DAE013-001	2016-03-14-1
4	1	D3186-2P Spacepod Doors	D3186 Rev.E	B137539	DAE013-002	2016-03-14-2

FAI article: PO Item 2.

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature: 
Jules Fournier, BDI, Quality Manager

Date: 2016-03-31



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO31394**

Purchase Order Date 2/17/2016

PO Print Date 10/4/2016

Page Number 2 of 4

Order From : VC-FDC01
FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 450-357-1344 ext303

Ship To Contact
Ship To Phone
Ship Via: —
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

3	D3188-2P	Spacepod Body	7/27/2016	1.00	\$2,460.00	\$2,460.00
			Yes	Each		
			7/27/2016			

AS PER DWG D3188 REV.G

B137538

D3188-2P

10/4/2016

1.00

\$2,680.00

\$2,680.00

Each

10/12/2016

PRICE FOR REWORK PER QUOTE 1356
REQUIRE REWORKED BODY AND DOOR ON OR BEFORE OCT 12

Line Total: \$5,140.00

4 D3186-2P Spacepod Door

4/8/2016

1.00

\$810.00

\$810.00

Yes

Each

4/7/2016

AS PER DWG D3186 REV.E

B137539

Line Total: \$810.00

Note:

10/4/2016

FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5
Tel.: 450 357-1344

Shipping Order

12/10/2016

Order : 2538
Reference : PO #31394/8

Customer: Dart

DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Ship To

DART AEROSPACE LTD
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7
Tel.: 1 613 632-9577

Item No.	Description	Qty	Qty. Delivered	B/O Qty
D3186-2P ✓	Spacepod Door PO item: 31394/8 FDC ID: DAE013-003 Lot: 2016-03-29	1 ✓	_____	_____
D3188-2P ✓	Spacepod Body PO item: 31394/8 FDC ID: DAE014-003 Lot: 2016-05-09 PRICE FOR PART D3188-2P IS INCLUDED IN PRICE FOR PART D3186-2P PARTS WERE GIVEN TO ERIC DOWNING FOR RETURN TO DART AEROSPACE	1 ✓	_____	_____

8/16-10-12

Shipping : _____
Package No : _____
Merchandise Received: _____

Ref. : _____

CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

Customer P/O Number: 31394

Revision: N/A

PO Item	Qty	Part number	Description	Dwg number Part	FDC ID	Lot
8	1	TBD	D3186-2 Side Door Repair	D3186 Rev.E	DAE013-003	2016-03-29
8	1	TBD	D3188-2 Spacepod Body Repair	D3188 Rev.G	DAE014-003	2016-05-09

Modified as per Dart's special instruction

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature: 
Karim Malihy, B Eng, Quality Manager

Date: 12 Oct 2016